

12/9

Work Order ID 152245

152245

Item ID: D350-567-141

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Floor Window Close Out

Start Date: 11/28/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 12/8/2016 Req'd Qty: 2.00

2

Customer:

Reference:

DAS
21
9-89

Approvals:

Process Plan:

Date: OCT 26 2016

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

DSI 9590

F

100

Document Control

0.00

100

DC

Doc.Control -USB or Paperwork

Memo

Photocopy bluefile & type labels per PPP D350-567-141 CHG004

DAS
6
89
DEC 09 2016

DAS
21
9-89

10-18-23
C

DEC 09 2016

DAS
27
9-89

110

Pick Kit

0.00

110

Packaging

Packaging

Memo

0.00

2 NOV 23 2016

DAS
6
9-89

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Quality Control

Memo

0.01

2 DAS
27
9-89

DEC 09 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐		☐	Pressure/Forced	☐	Temperature/Cure
Design ☐	☐	Operator ☐		☐	Bending	☐	Set-up
Doc/Data ☐	☐	Offset/Setup ☐		☐	Centre Not Concentric	☐	BOM/Route
Equip/Tooling ☐	☐	Supplier ☐		☐	Cracks	☐	Broken/Damage/Defect
Handling/Pre ☐	☐	Training ☐		☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified
Material ☐	☐	Use for Testing ☐		☐	Cuffs	☐	Contamination
Internal Transport ☐	☐	Poor Information ☐		☐	Crushing	☐	Countersink
Tribal Knowledge ☐	☐	Rushing ☐		☐	Heat Treat	☐	Cut Too Short
LOA ☐	☐	Product Improvement ☐		☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear
Substation ☐	☐	Process Improvement ☐		☐	Marks/Chatter	☐	Drill Holes
Past Expiry Date ☐	☐	Manufacturing Process ☐		OTHER :			
Misidentified ☐	☐	Past Due ☐					

Work Order ID 152245

Friday, October 21, 2016 3:02:57 PM

152245

Page 2

Item ID: D350-567-141

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Floor Window Close Out

Stop ***NS2***

Start Date: 11/28/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 12/8/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-567-141 Location:FG033								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.03							
Quality Control									

2X
DAS 28
27 1-89
9-89

DEC 09 2016

DAS
21
9-89

DEC 09 2016

DAS
21
9-89

DEC 09 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

Friday, October 21, 2016 3:02:56 PM

Page 1

Work Order ID: 152245

152245

Parent Item: D350-567-141

D350-567-141

Parent Item Name: Floor Window Close Out

Start Date: 11/28/2016

Required Date: 12/8/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 11.11.09 new issue DD verf:JLM IPP REV:B
12.01.23 AS PER ECN12-511 DD VERF:EC IPP REV:C 12.03.05
AS PER ECN12-537 DD VERF:EC IPP REV:D 13.04.01 AS PER
DSI9590 REV.E DD VERF:JLM IPP REV :E AS PER DSI9590 REV F JLM
VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4434-047		Manufactured	No				Each	0.0000		2			
-----------	--	--------------	----	--	--	--	------	--------	--	---	--	--	--

D4434-047

Cover Assembly

D3802-1

D3802-1

Window Seal (\$ per foot)

DAS
27
9-89

Location

Loc Qty

Loc Code

ST416

37.591836

146267

1.591836

147067

1.5

147802

34.5

D4434-041

Manufactured No

110

Each

2.0000

1

D4434-041

Fwd Bracket Assembly

DAS
27
9-89

Location

Loc Qty

Loc Code

ST623

2

148930

2

D4435-045

Manufactured No

110

Each

2.0000

1

D4435-045

T/R Bellcrank Cover Assembly

DAS
27
9-89

Location

Loc Qty

Loc Code

ST620

2

147625

2

DAS 28 9-89
NOV 23 2016

DAS 28 9-89
NOV 22 2016

4 feet
DAS 28 9-89
NOV 22 2016
DAS 28 9-89
DEC 08 2016

152205
DAS 28 9-89
DEC 09 2016
DAS 28 9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ No Re-verification ☐ Design ☐ Operator ☐ Doc/Data ☐ Offset/Set-up ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Temperature/Cure ☐ Bending ☐ Set-up ☐ Centre Not Concentric ☐ BOM/Route ☐ Cracks ☐ Broken/Damage/Defect ☐ Crimp/Kink/Ripple/Wave ☐ Inspection Incomplete/Unqualified ☐ Cuffs ☐ Contamination ☐ Crushing ☐ Countersink ☐ Heat Treat ☐ Cut Too Short ☐ Wave/Twist in Tube ☐ Instructions Incomplete/Unclear ☐ Marks/Chatter ☐ Drill Holes ☐		Power Loss/Surge ☐ Positioned Wrong ☐ Folio/Program ☐ Outside Dimensions ☐ Grain ☐ Over/Under tolerance ☐ Weld ☐ Part Incorrect ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Out of Sequence ☐ Part Moved ☐ Off-set ☐ Drawing ☐ Misabeled ☐ Finish ☐ Fit/Function ☐ Misread ☐ Misaligned/off center ☐ Turning Sequence ☐					
		OTHER : _____							

Picklist Print

Friday, October 21, 2016 3:02:56 PM

Page 2

Work Order ID: 152245

152245

Parent Item: D350-567-141

D350-567-141

Parent Item Name: Floor Window Close Out

Start Date: 11/28/2016

Required Date: 12/8/2016

Start Qty: 2.00

Required Qty: 2.00

D4435-9 Manufactured No

110 Each 13.0000 2 4

D4435-9

Bracket

**

NOV 23 2016

DAS 6 9-89

DAS 6 9-89

DAS 27 9-89

Location

Loc Qty

Loc Code

ST098

13

145909

13

D4436-041

Manufactured No

110 Each 1.0000 1 2

D4436-041

Aft Bracket Assembly

**

31223X1
1XB154056

DEC 08 2016

NOV 23 2016

DAS 6 9-89

DAS 6 9-89

DAS 27 9-89

Location

Loc Qty

ST618

1

149659

1

D4441-1

Manufactured No

110 f 0.0001 2 4

D4441-1

Rubber Seal

**

157347

DAS 6 9-89

DAS 6 9-89

DEC 07 2016

DAS 27 9-89

Location

Loc Qty

Loc Code

ST422

0.0001

120932

0.0001

AN3-3A

Purchased No

110 Each 179.0000 7 14

AN3-3A

Bolt

**

NOV 23 2016

DAS 6 9-89

DAS 6 9-89

DAS 27 9-89

Location

Loc Qty

Loc Code

over003

50

m135865

50

ST350

129

m135466

64

m135566

15

m135672

50

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

Picklist Print

Friday, October 21, 2016 3:02:56 PM

Page 3

Work Order ID: 152245

152245

Parent Item: D350-567-141

D350-567-141

Parent Item Name: Floor Window Close Out

Start Date: 11/28/2016

Required Date: 12/8/2016

Start Qty: 2.00

Required Qty: 2.00

AN525-10R6

Purchased

No

110

Each

313.0000

2

4

AN525-10R6

Screw

**

NOV 23 2016

DAS 23 9-89

Location

Loc Qty

Loc Code

ST329

313

M134502

313

AN525-832R7

Purchased

No

110

Each

80.0000

2

4

AN525-832R7

Screw

**

NOV 23 2016

DAS 23 9-89

Location

Loc Qty

Loc Code

GA

27

m134070

27

ST328

53

m134070

53

MS21042L06

Purchased

No

110

Each

114.0000

7

14

MS21042L06

Nut

**

NOV 23 2016

DAS 23 9-89

Location

Loc Qty

Loc Code

ST303

114

m135274

14

m135766

100

MS21042L08

Purchased

No

110

Each

571.0000

2

4

MS21042L08

Nut

**

NOV 23 2016

DAS 23 9-89

Location

Loc Qty

Loc Code

GA

100

m135274

100

ST303

471

m135566

71

m135672

200

m135766

200

Friday, October 21, 2016 3:02:56 PM

Shop Packet Print

Page 3

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step # : _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

Picklist Print

Friday, October 21, 2016 3:02:56 PM

Page 4

Work Order ID: 152245

152245

Parent Item: D350-567-141

D350-567-141

Parent Item Name: Floor Window Close Out

Start Date: 11/28/2016

Required Date: 12/8/2016

Start Qty: 2.00

Required Qty: 2.00

MS21042L3

Purchased

No

110

Each

1,469.000

5

10

MS21042L3

Nut

**

NOV 23 2016

DAS 28 9-89

Location

Loc Qty

Loc Code

FP001

7

M130922

7

GA

225

m134360

108

m135135

117

OVER007

600

m135767

600

ST303

637

m135530

600

m135600

37

DAS 27 9-89

10

MS21059L3

Purchased

No

110

Each

104.0000

2

4

MS21059L3

Nut Plate

**

NOV 23 2016

DAS 28 9-89

Location

Loc Qty

Loc Code

GA

32

M135603

32

ST301

72

M135704

12

M135774

60

DAS 27 9-89

MS35206-229

Purchased

No

110

Each

396.0000

7

14

MS35206-229

Screw

**

NOV 23 2016

DAS 28 9-89

Location

Loc Qty

Loc Code

ST271

396

M134070

46

M135603

350

DAS 27 9-89

74

Friday, October 21, 2016 3:02:56 PM

Shop Packet Print

Page 4

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

Friday, October 21, 2016 3:02:56 PM

Page 5

Work Order ID: 152245

152245

Parent Item: D350-567-141

D350-567-141

Parent Item Name: Floor Window Close Out

Start Date: 11/28/2016

Required Date: 12/8/2016

Start Qty: 2.00

Required Qty: 2.00

NAS1149F0332P

Purchased

No

110

Each

1,350.000

12

24

NAS1149F0332P

Washer

**

135948

DAS

6

9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

282

m133709

282

ST262

1068

m135544

1068

NAS1149FN616P

Purchased

No

110

Each

82.0000

14

28

NAS1149FN616P

WASHER

**

NOV 23 2016

DAS

6

9-89

DAS

2

9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST264

82

M135274

82

NAS1149FN816P

Purchased

No

110

Each

736.0000

2

4

NAS1149FN816P

WASHER

**

NOV 23 2016

DAS

6

9-89

DAS
73
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST263

736

117316

736

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : _____							

Work Order ID 152245

Wednesday, November 23, 2016 10:29:23 A

152245

Page 1

Item ID: D350-567-141**Accept*****N900040100*****Setup Start*****NS1*****Revision ID:****Stop*****NS2*****Item Name:** Floor Window Close Out**Start Date:** 11/28/2016 **Start Qty:** 2.00***2*****Cust Item ID:****Required Date:** 12/8/2016 **Req'd Qty:** 2.00***2*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start*****NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop*****NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9590	F								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D350-567-141 CHG004								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.01							
Quality Control									

DAS
21
9-89

NOV 23 2016

REFERENCE ONLY

2.0 Parts List

Qty -141	Qty -143	Qty -145	Part Number	Description
X			D350-567-141	FLOOR WINDOW CLOSE-OUT KIT (REGULAR SEATS)
	X		D350-567-143	FLOOR WINDOW CLOSE-OUT KIT (ENERGY ATTENUATING SEATS)
		X	D350-567-145	FLOOR WINDOW CLOSE-OUT KIT (AS 350 B3e)
1	1	1	D3802-1-024	SEAL (24")
1	1		D4434-041	FWD BRACKET ASSEMBLY
1	1		D4434-047	COVER ASSEMBLY
1			D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	2	2	D4435-9	BRACKET
1	1	1	D4436-041	AFT BRACKET ASSEMBLY
1	1	1	D4441-1-240	RUBBER SEAL (24")
		1	D4730-020-030	VELCRO STRIP
	1	1	D4971-041	T/R BELLCRANK COVER ASSEMBLY
		1	D5076-041	FWD BRACKET ASSEMBLY
7	5	5	AN3-3A	BOLT
2	2	2	AN525-10R6	SCREW
2	2	2	AN525-832R7	SCREW
		1	CB 200	3.5g ACRYLIC ADHESIVE
7	7	7	MS21042L06	NUT (OR MS21042-06)
2	2	2	MS21042L08	NUT (OR MS21042-08)
5	5	5	MS21042L3	NUT (OR MS21042-3)
2	2	2	MS21059L3	NUTPLATE
7	7	7	MS35206-229	SCREW
12	10	10	NAS1149F0332P	WASHER (AN960-10L)
14	14	14	NAS1149FN616P	WASHER (OR AN960-6L)
2	2	2	NAS1149FN816P	WASHER (OR AN960-8L)

3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141/-143/-145 Kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141/-143/-145 Floor Window Close-out Kit	3.9 lb 1.77 kg	17.9 in 0.45 m	69.8 in-lb 0.80 m-kG	65.5 in 1.66 m	255.5 in-lb 2.94 m-kG

4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141/-143/-145 Close-out Kits. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
 - D350-567-115 - OK to remove D3295-041
 - D350-567-031 - OK to remove D3212-1
 - D350-567-011 - OK to remove D2214
 - D350-567-021 - OK to remove D2951
- It is acceptable to drill/trim the D350-567-141/-143/-145 Close-out Kits as required to improve fit.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-Q-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 15.01.12
CERT. NO.: SH92-18
ISSUE NO.: 6

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.	N/A	DSI 9590	SHEET 2 OF 19
APPROVED		TITLE	SCALE
DE APPR.		FLOOR WINDOW CLOSE-OUT KIT	NTS
DATE	15.01.12	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	